



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

D3407-1
Job Sheet 169882



Part No: D3407-1

Job Qty: 30 ea

Part Name: Stem



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/3/18

Job Tracking No:

Due Date: 1/12/18

Created By: Mario Poulin

Type: Stock

Description:

Note: IPP Rev:A 05.10.18 New issue KJ/EC IPP Rev:B Now on Doosan 08-05-14 JLM Verified By:DD IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC IPP REV:D 17.11.02 AS PER DWG REV.G DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea	1/11/18	1/11/18	0.00	0.00	Start Up Machining-2		<i>MDP</i> 12/21/18
100	Doosan	30 pcs	1/12/18	1/12/18	0.00	12.05	Doosan		<i>MDP</i> 12/21/18
110	QC	30 pcs	1/12/18	1/12/18	0.00	0.00	QC2 Machining-2		<i>MDP</i> 12/21/18
120	QC	30 pcs	1/12/18	1/12/18	0.00	0.00	QC8 Machining-2		<i>MDP</i> 10/02/05
130	Packaging	30 pcs	1/12/18	1/12/18	0.00	0.00	Packaging3-1		<i>EL</i>
140	QC21-SA	30 Ea	1/12/18	1/12/18	0.00	0.00	QC21		

Part Op 100 - 1-Turn as per Folio FA596 Rev: ____ & Dwg D3407 Rev: ____ Mill slot width at max tolerance .260"
Descriptions: 130 - LOCATION: WA001

FEB 06 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M17-4-R0.750	14	53	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Tow Ring <i>0.263</i>	0.063Inches ± 0.010	0.073 0.053		
2	Tow Ring <i>0.265</i>	0.26520inches	+ 0.00160 - 0.00170	0.26680 0.26350	1/4-28 UNF
3	Tow Ring <i>0.245</i>	0.24575inches ± 0.00325	0.24900 0.24250	Major □	
4	Tow Ring <i>0.625</i>	0.625Inches ± 0.010	0.635 0.615		
5	Tow Ring <i>0.363</i>	0.363Inches ± 0.010	0.373 0.353		
6	Tow Ring <i>0.747</i>	0.750Inches ± 0.010	0.760 0.740		
7	Tow Ring <i>0.100</i>	0.100Inches ± 0.010	0.110 0.090	Radius	
8	Tow Ring <i>0.472</i>	0.470Inches ± 0.010	0.480 0.460		
9	Tow Ring <i>0.501</i>	0.500Inches ± 0.010	0.510		

DART
AEROSPACE
S037665

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Stem

PART NO: D3407-1
Original Serial #: S037665
Revision:
Operation:
Change No:

Start up Operation

01/31/18
Job No: 169882

				0.490
10	Tow Ring	3.250	3.25Inches ± 0.01	3.26 3.24
11	Tow Ring	4.245	4.250Inches + 0.000 - 0.010	4.250 4.240
12	Tow Ring	5.270	5.270Inches ± 0.010	5.280 5.260
13	Tow Ring	0.153	0.150Inches ± 0.010	0.160 0.140
14	Tow Ring	0.552	0.550Inches ± 0.010	0.560 0.540
15	Tow Ring	0.625	0.625Inches ± 0.010	0.635 0.615
16	Tow Ring	0.258	0.250Inches + 0.010 - 0.000	0.260 0.250

Plex 1/3/18 8:16 AM dart.poulin.mario